

Date: Wednesday, 1/30/2008 7:57:10 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HANDLE
Job Number : 37083	
Estimate Number : 11212	
P.O. Number :	Part Number : D33321
This Issue : 1/30/2008 S.O. No. :	Drawing Number : D3332 REV A1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : LARGE FAB-ASSY	Drawing Revision : A1
Previous Run : 35935	Material :
Written By : <u>JA 08 01 30</u>	Due Date : 2/11/2008 Qty: 20 Um: Each
Checked & Approved By : <u>JA 08 01 30</u>	
Comment : Est: B 05.06.20 Holes no longer made by machine KJ/JL M	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
---------	-----------------------	--------------

1.0	M1018R2000	1018-1025 Steel Bar
-----	------------	---------------------



Comment: Qty.: 0.0218 f(s)/Unit Total: 0.4368 f(s)
 1018-1025 Steel Bar
 Material: AISI 1018-1025 Ø2.00" Round Bar
 (M1018-R2.000)
 Identify for D3332-1
 Batch: M16639

J.F. 08/01/31

(21)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: ~~HARDINGE CNC LATHE SMALL~~
 Turn as per Folio FA494 and Dwg D3332

J.F. 08/01/31

(21)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. 08/01/31

(21)

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1
 Drill as per Dwg D3332 and Deburr using D3338-041-T1
 Identify as D3332-1

FF 08-05-21

(21)

5.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

counters
 08/05/21 (x21)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/30/2008 7:57:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE

Job Number: 37083

Part Number: D33321

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W522*

Pl 08.05.22

(X21)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



08/05/23 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-05-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

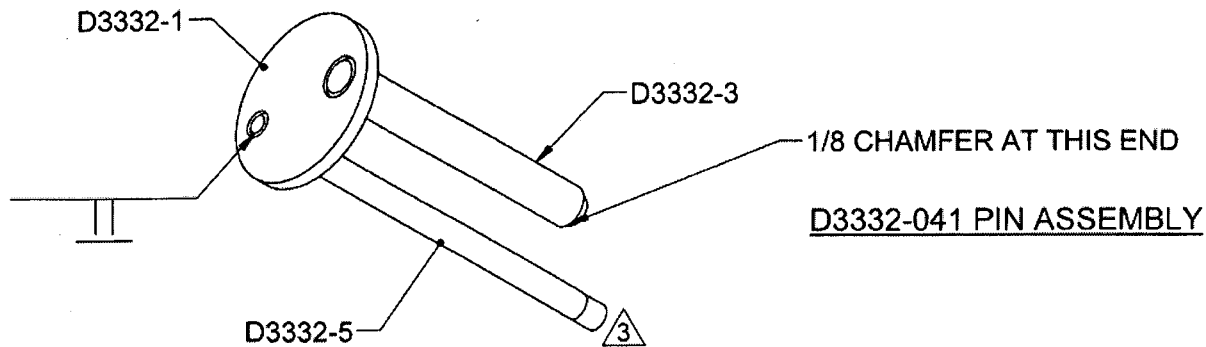
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

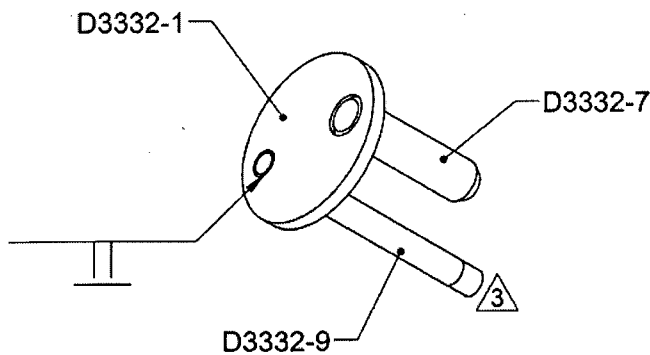


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3332	REV. A SHEET 1 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:2
A	04.12.14	NEW ISSUE	
A1	<i>[Signature]</i> 05.07.04	0.080 WAS 0.050; ADD TOLERANCE ± 0.000 ± 0.005	



D3332-041 PIN ASSEMBLY

RELEASED
[Signature]
05/02/09



D3332-043 PIN ASSEMBLY

NOTES:

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) MASK THREADS PRIOR PAINTING
- 4) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
(COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.10

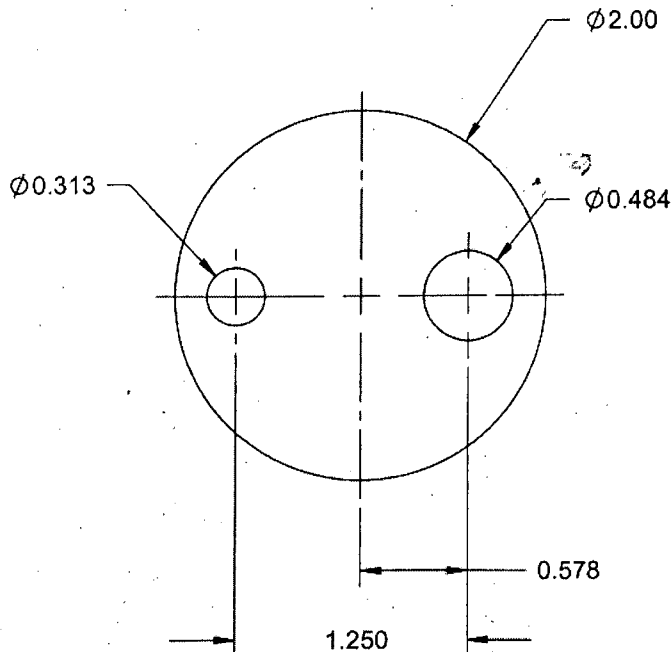
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37083

COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3332	REV. A SHEET 2 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



RELEASED
[Signature]
05/02/09

D3332-1 HANDLE

NOTES:

- 1) MATERIAL: 1018-25 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018-R2.000)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **37083**

3918

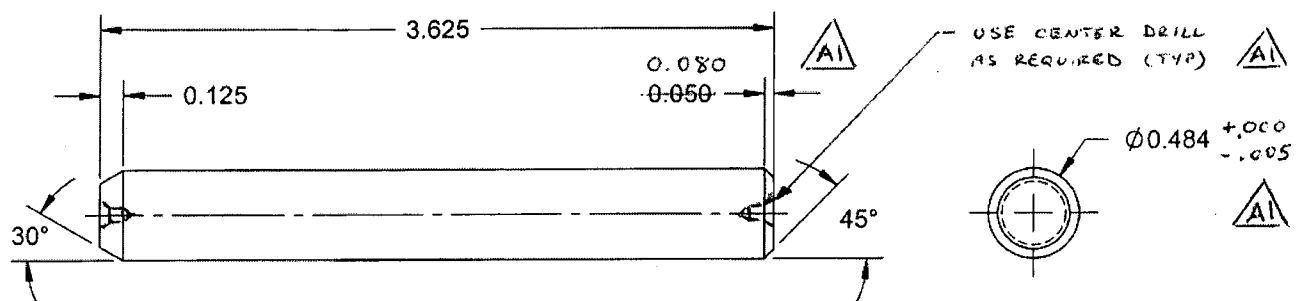
*242
156*

COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

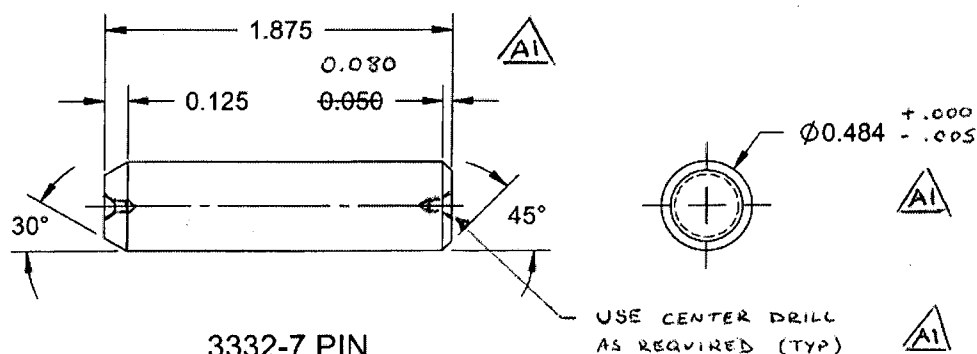


DESIGN <i>A3</i>	DRAWN BY <i>A3</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>RT</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3332	REV. A SHEET 3 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



3332-3 PIN

RELEASED
[Signature]
05/02/09



3332-7 PIN

NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097 (REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

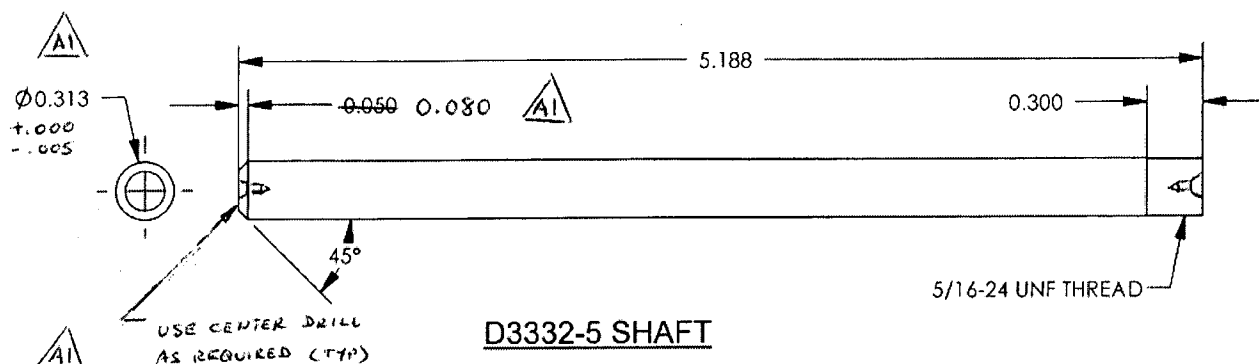
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **37083**

COPYRIGHT © 2004 BY DART AEROSPACE LTD.

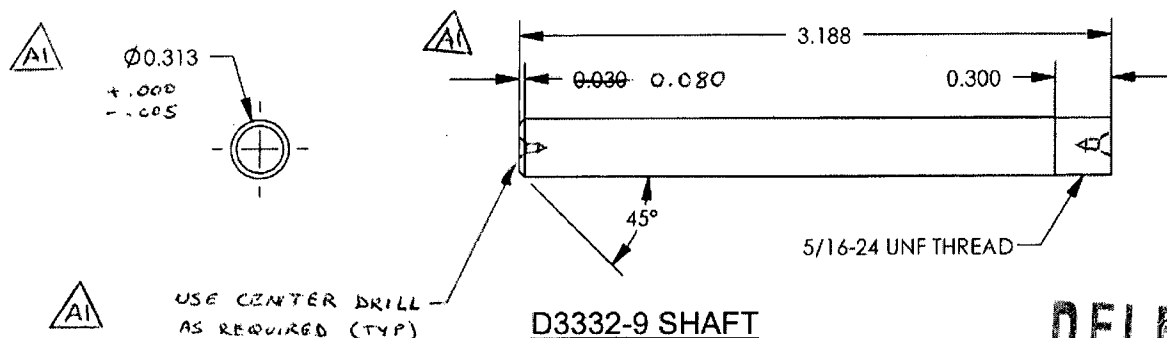
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>A3</i>	DRAWN BY <i>A3</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3332	REV. A SHEET 4 OF 4
DATE 04.12.14		TITLE PIN ASSEMBLY	SCALE 1:1



D3332-5 SHAFT



D3332-9 SHAFT

RELEASED
[Signature]
05/02/09

NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37083

COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.